



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
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D4417-041
Job Sheet 179940



Part No: D4417-041

Job Qty: 1 ea

Part Name: Step Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/26/18

Job Tracking No:

Due Date: 6/29/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B SHEETS 3,4 IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC IPP REV:B 11.08.17 PER REV.B. DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/29/18	6/29/18	0.00	0.00	Start Up Large Fab-4		DML 18-6-26
100	Large Fab	1 pcs	6/29/18	6/29/18	0.00	1.76	Large Fab 8		DML 18-6-26
120	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC5		18-06-26
130	HandFinish	1 pcs	6/29/18	6/29/18	0.00	0.36	HandFinish1		BEB 18-06-27
140	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC7-3		CPC
150	Large Fab	1 pcs	6/29/18	6/29/18	0.00	1.76	Large Fab 2		CPC
160	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC10		18-06-27
170	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC5		18-06-28
180	Powdercoat	1 pcs	6/29/18	6/29/18	0.00	0.26	Powdercoat1		18-6-28
190	HandFinish	1 pcs	6/29/18	6/29/18	0.00	0.36	HandFinish3		18-6-28
200	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC3		18-6-28
210	Packaging	1 pcs	6/29/18	6/29/18	0.00	0.00	Packaging3-2		21
220	QC21-SA	1 Ea	6/29/18	6/29/18	0.00	0.00	QC21		21 JUN 28 2018

Part Op 100 - 1-Cut D2622 to 106"AS PER DWG 2-DRILL HOLES USING DT9765 3-CUT ENDS AT 45 DEG AS PER DWG 4-Descriptions: OPEN HOLES AT 0.508" AS PER DWG

150 - 1-SWAGE TUBES AS PER DWG 2-Weld cap per dwg D4417 3-grind flush

480 - 1-Touch up alodine START TIME: 9:25 OVEN TEMPERATURE: 320° FINISH TIME: 9:55

Touchup Alodine BEB 18-06-28

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	1 Ea (1 ea)	90-Start up Operation	3046116
D2734	Step End Plate	2 Ea (2 ea)	150-Large Fab	5077383
D4425-1	Step Spacer	2 Ea (2 ea)	150-Large Fab	F140054

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	1	52	0
150-Large Fab	D2734	2	36	0
	D4425-1	2	2	0

Part Specifications

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
			Completed By																		
			Lead hand / Supervisor Approval Verification																		
			QC / QA Coordinator Approval																		
<table style="width:100%; border: none;"> <tr> <td style="width:25%; vertical-align: top;"> Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:25%; vertical-align: top;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> <td style="width:25%; vertical-align: top;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:25%; vertical-align: top;"> FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:25%; vertical-align: top;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:25%; vertical-align: top;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>						Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐										
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OTHER : _____																					



DQA: _____ Date: _____
QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Work Order: _____	Suspected Unapproved	Skid-tube	Cross tube	Water Jet	Engineering
Part No. _____		Machining	Small Fab	Prod. Eng. Coord.	Quality
NCR No. _____		Thermoforming	Finishing	Rec/Store/Packaging	Other
Date: _____	Step #: _____	Large Fab	Composite	Supplier	Approval
Description Work Order Deviation					
Root Cause		Wrong dimensions tolerance			
Environment	No Re-verification	Pressure/Forced	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Incorrect
Design	Operator	Bending	Contamination	Out of Sequence	Part Lost/Missing
Doc/Data	Offset/Setup	Centre Not Conc	Countersink	Off-set	Part Moved
Equip/Tooling	Supplier	Cracks	Cut Too Short	Mislabeled	Drawing
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Instructions Incomplete/Unclear	Fit/Function	Finish
Material	Use for Testing	Cuffs	Drill Holes	Misaligned/off center	Misread
Internal Transport	Poor Information	Crushing			Turning Sequence
Tribal Knowledge	Rushing	Heat Treat			
LOA	Product Improvement	Wave/Twist in Tube			
Substation	Process Improvement	Marks/Chatter			
Past Expiry Date	Manufacturing Process				
Misidentified	Past Due				
OTHER: _____					

DART
AEROSPACE

Container No: S084626

Part: D4417 - 041
Job No: 179940
Serial No/Batch: S084626

Revision:
Inspector:
Exp Date:
Instructions:

Date: 06/26/18

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Supervisor
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Coordinator
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